Dart Aerospace Ltd.

Date: Tuesday, 4/17/2007 3:52:45 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/355 AS X-TUBE AFT
Job Number	: 31907		
Estimate Number	: 12486		
P.O. Number	: N/A	Part Number	: D350748201
This Issue	: 4/17/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 29765	Material	: N/A
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.18		
Comment	: Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update qty of MS21042L5 06-09-12 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001	KS 07.05.10
2.0	31907A	X-TUBE AS 350/355 HI AFT UNDER REVIEW
	Comment: Sub-Component X-TUBE AS 350/355 HI AFT D350-748-241 B 31907A	7/8/22
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
4.0	D35001	350 SADDLE
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) 350 SADDLE Batch: B28794	
5.0	D35011	BUSHING
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) BUSHING Batch: B28478	07/08/22

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:52:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 31907
Part Number: D350748201

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	AN46A	Bolt
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Bolt Batch: M103962	
7.0	AN441A	bolt
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) bolt Batch: M102552	
8.0	AN532A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: M102850	
9.0	AN960JD416	Washer
	Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s) Washer Batch: M104215	
10.0	AN960JD516	Washer
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Washer Batch: M104156	
11.0	MS21042L4	Nut
	Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s) Nut Batch: M102552	
12.0	MS21042L5	Nut
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut Batch: M104547	

04/08/2020

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/08/23

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:52:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 350/355 AS X-TUBE AFT

Job Number: 31907 | **Part Number:** D350748201

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	
14.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D350-748-201 Location:__________ PPP Rev:__________ A	7/8/22 SP
15.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE AS 350/355 HI AFT ~~UNDER REVIEW~~
Job Number	: 31907A		
Estimate Number	: 12483		
P.O. Number	: N/A	Part Number	: D350748241
This Issue	: 4/17/2007 S.O. No. : N/A	Drawing Number	: D350-748-241 ~~U/R~~ OK 07.04.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: ~~C~~ D
Previous Run	: 29765A	Material	: N/A
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.18		
Comment	: Est Rev: A New Issue 06-07-05 JLM		
	Est Rev: B Update cadplate process 06-09-12 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels as per PPP D350-748-241 CHG001 N/A. ~~07/04/21~~

Seq. #:	Machine Or Operation:	Description :
2.0	D6018125	Crosstube Material

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Material
D6018-125
2.299" OD X 2.000" ID
Batch: B27472 07/04/27

Seq. #:	Machine Or Operation:	Description :
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241. 07/04/27

Seq. #:	Machine Or Operation:	Description :
4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET MS 07/04/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31907A **Part Number:** D350748241

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241 MS 07/04/27

Seq. #:	Machine Or Operation:	Description :
6.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET MS 07/04/27

Seq. #:	Machine Or Operation:	Description :
7.0	QC8	SECOND CHECK

Comment: SECOND CHECK BC 07.04.30 (1)

Seq. #:	Machine Or Operation:	Description :
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
Remove all Machining Marks JD 7-5-3

Seq. #:	Machine Or Operation:	Description :
9.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG

Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 3777 CL 07/05/15 (1)
Heat Treat to min 180 KSI As per Dwg D350-748-241
Sand Blast tube after Heat Treat
Possibe Supplier: Vac Aero
Ensure Certificate of Conformity is attached

Seq. #:	Machine Or Operation:	Description :
10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformaty is attached 07/06/04 (2)

Seq. #:	Machine Or Operation:	Description :
11.0	QC6	DIMENSIONAL CHECK

07-07-04 (1)

Comment: DIMENSIONAL CHECK

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31907A **Part Number:** D350748241

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Oil inside of tube with LPS-3 .
A/R LPS-3 Batch: M 104161 EL 070709

13.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE
Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT______ EL 7-7-9

14.0	~~QC6~~ QC15	DIMENSIONAL CHECK

PTO

Comment: DIMENSIONAL CHECK 07-07-11

15.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Remove all marks from tube within limits of D350-748-241 DP 7-7-16

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241 N/A 07/07/11 (1)

16.0	QC6	DIMENSIONAL CHECK

07-18 (1)

Comment: DIMENSIONAL CHECK

17.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG

Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: U203 C 07/07/18
Stress relief at 375° for 5 hours (1)
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possibe Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
07-07-11	14.0	QC15 required. Perm. Change				07-07-11	07-07-11

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31907A | **Part Number:** D350748241

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached 7/8/17 SP (IX)

Seq. #:	Machine Or Operation:	Description :
19.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP En 07/08/17 (XC)

Seq. #:	Machine Or Operation:	Description :
20.0	SPRAY PAINTING	SPRAY PAINTING

Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2 ml 07 08 19 (1)

Seq. #:	Machine Or Operation:	Description :
21.0	QC14	INSPECT SPRAY PAINT

Comment: Inspect Spray Paint
Then,Wrap in plastic bag to protect from scratches 4T 07-08 21

Seq. #:	Machine Or Operation:	Description :
22.0	D35021	SUPPORT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SUPPORT
Batch: 28476 4T 07-08-21

Seq. #:	Machine Or Operation:	Description :
23.0	D2856400	Abrasion Strip

Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)
Abrasion Strip 7.10" long x2
Batch: 32020 4T 07 08 21

Seq. #:	Machine Or Operation:	Description :
24.0	ALS41032225	Insert

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Insert
Batch: 19393 4T 07 08-21

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31907A

Part Number: D350748241

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	AN960JD10	Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
Batch: 104885   ET 07-08-21

Seq. #:	Machine Or Operation:	Description :
26.0	MS2192020	Clamp (per MIL-DTL-8783C)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Clamp (per MIL-DTL-8783C)
Batch: 104902   ET 07-08-21

Seq. #:	Machine Or Operation:	Description :
27.0	MS27039110	Screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Screw
Batch: 18836   ET 07-08-21

Seq. #:	Machine Or Operation:	Description :
28.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert,then insert screw and washer

2-Install Abraision strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241,Torque to 60-80 IN-LBS

ET 07-08-21

Seq. #:	Machine Or Operation:	Description :
29.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   ET 7/08/08 (X1)

Seq. #:	Machine Or Operation:	Description :
30.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-748-241   31907
Location:__________
PPP Rev:__________

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes (No) DQA: RD Date: 07/08/23

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31907A
Part Number: D350748241

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31907A
Description: Crosstube Assembly (AS350/355 High Aft)	Part Number:	D350-748-241
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

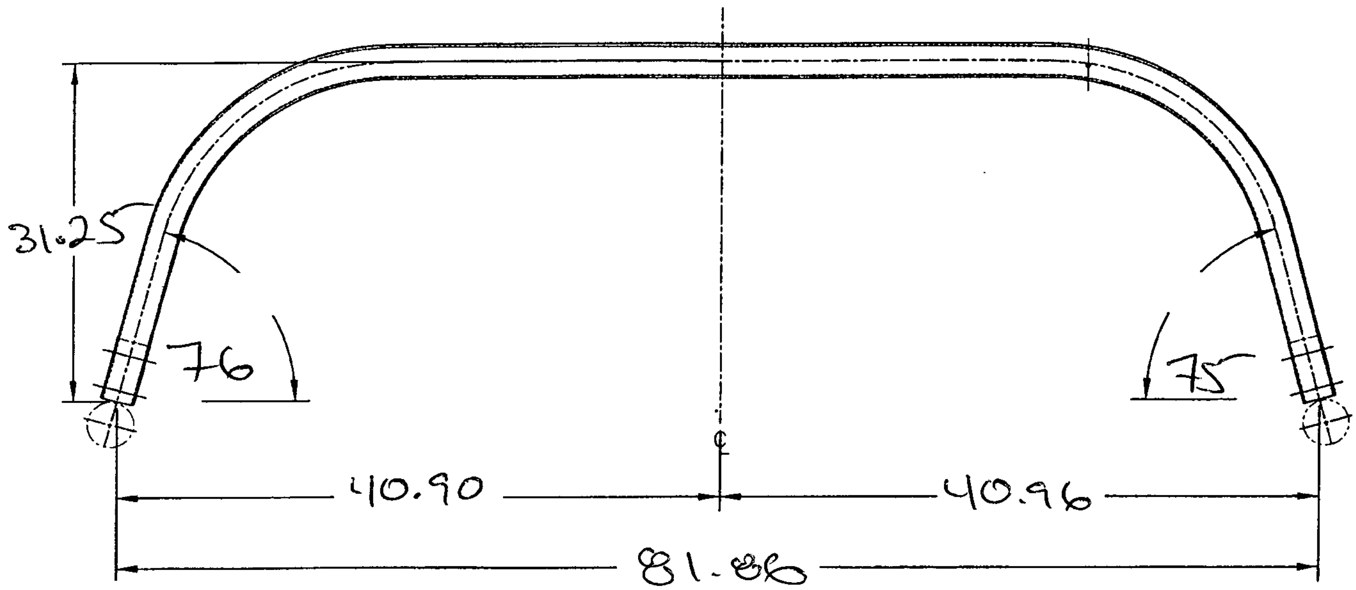
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.236	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.274	✓			
	2.299	+0.005/-0.000	2.301	✓			
	0.063	+/-0.010	.063	✓			
	4.26	+/-0.030	.426	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	500	✓			
SIDE B	2.240	+0.005/-0.000	2.242	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.180	+0.005/-0.000	2.182	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.236	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.274	✓			
	2.299	+0.005/-0.000	2.301	✓			
	0.063	+/-0.010	.063	✓			
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	.500	✓			
	122.70	+/-0.060					

Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	07/04/27	Date:	07/04/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31907A.
Description: Crosstube High Aft (AS350/355)	**Part Number:**	**D350-748-201**
Inspection Dwg: D350-748-241 **Rev:** D		**Page 1 of 1**

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
height is even.

QC15 Inspection	[signature]
Date	07.07.11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM [initials]	[signature]

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D350-748-241 REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS

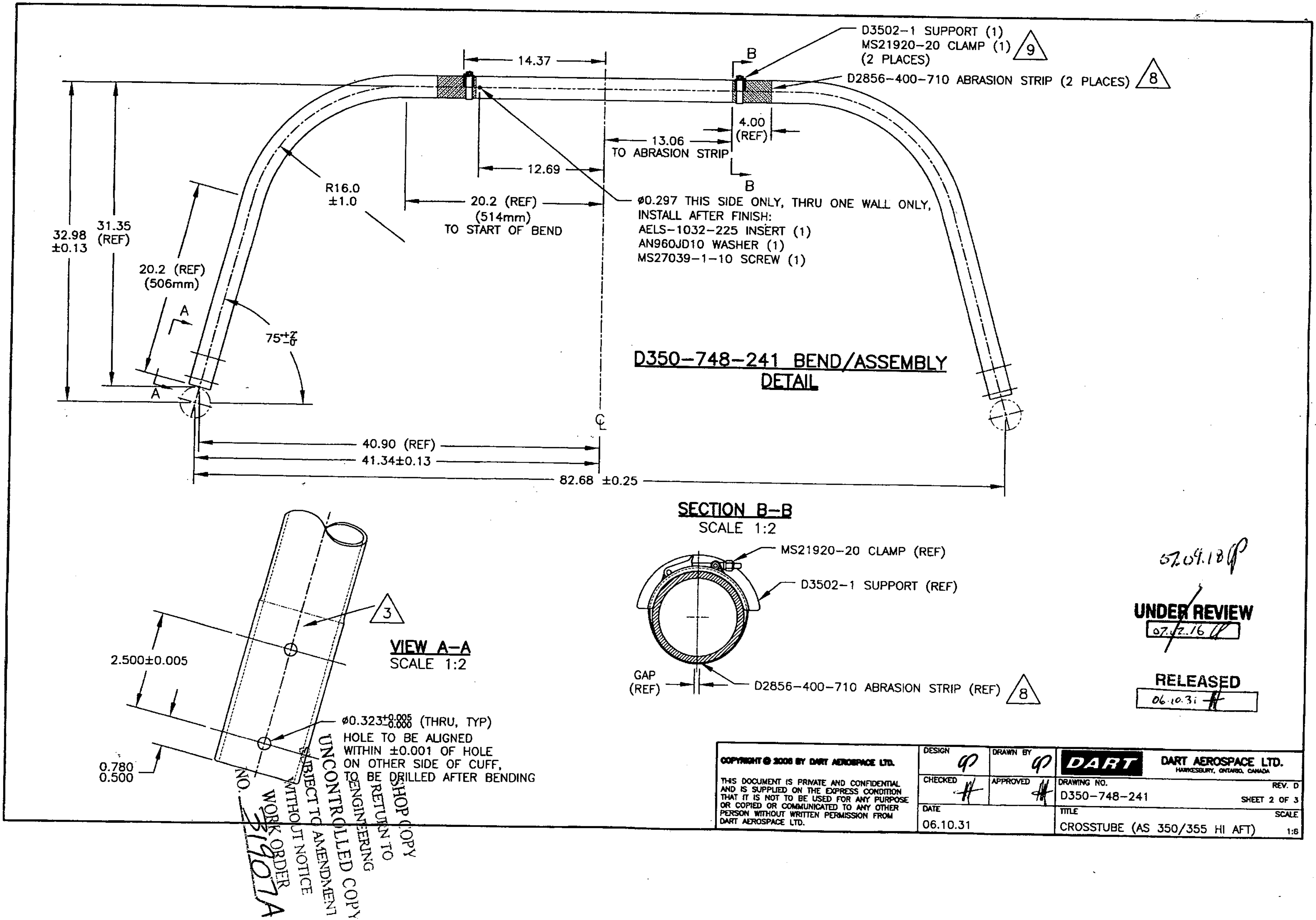
REV	DATE	DESCRIPTION
A	06.03.31	NEW ISSUE
B	06.06.30	ADD D6018-125 & PRIME AND PAINT
C	06.08.14	ADD CAD PLATING
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.

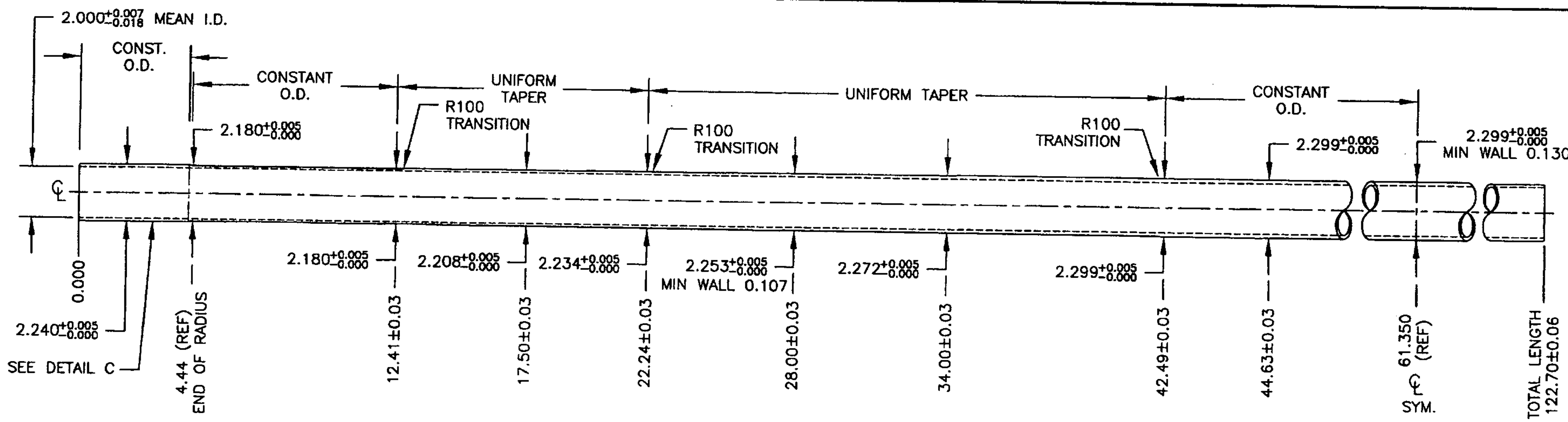
RELEASED 06.10.31

QTY	P/N	DESCRIPTION
X	**D350-748-241**	**CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)**
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

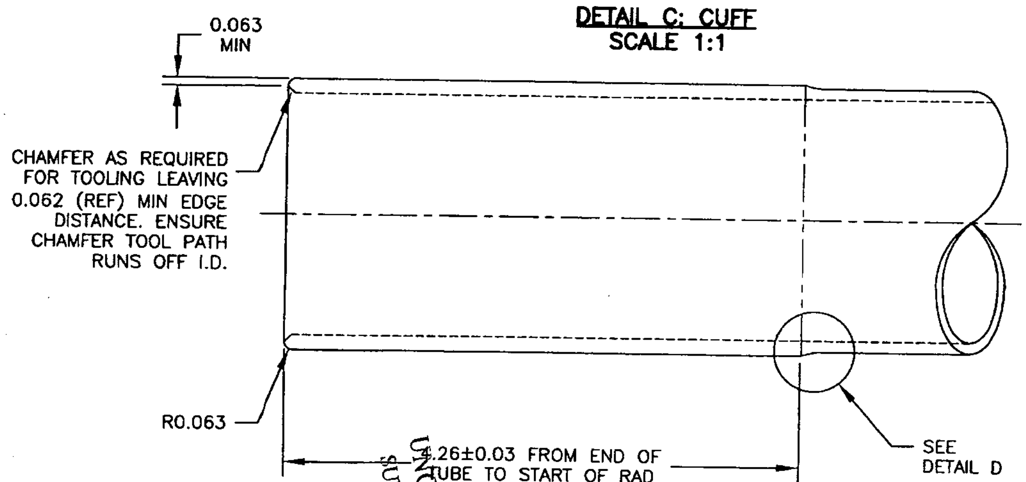
D350-748-141 CROSSTUBE:

1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
   FINISHED LENGTH = 122.70±0.06
2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
   CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
   PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
   PAINT OUTSIDE PER DART QSI 005 4.2
7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
11) ALL DIMENSIONS ARE IN INCHES
12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR ∅0.297 HOLE.

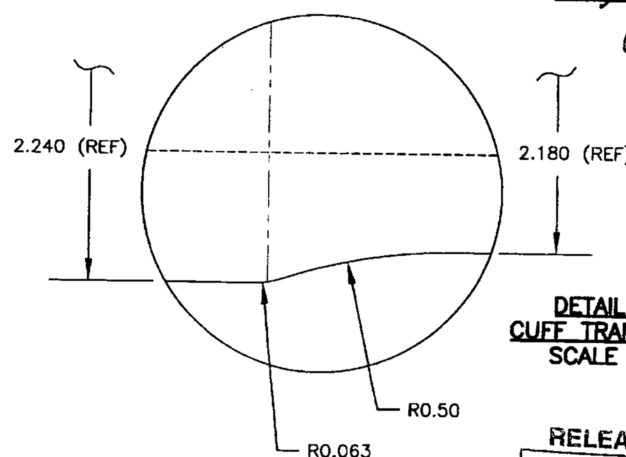

D350-748-241 BEND/ASSEMBLY DETAIL
D3502-1 SUPPORT (1)
MS21920-20 CLAMP (1) 9
(2 PLACES)
D2856-400-710 ABRASION STRIP (2 PLACES) 8
14.37
4.00 (REF)
13.06 TO ABRASION STRIP
12.69
R16.0 ±1.0
20.2 (REF) (514mm) TO START OF BEND
ø0.297 THIS SIDE ONLY, THRU ONE WALL ONLY, INSTALL AFTER FINISH:
AELS-1032-225 INSERT (1)
AN960JD10 WASHER (1)
MS27039-1-10 SCREW (1)
32.98 ±0.13
31.35 (REF)
20.2 (REF) (506mm)
75 +2 -0
40.90 (REF)
41.34±0.13
82.68 ±0.25
VIEW A-A
SCALE 1:2
2.500±0.005
0.780
0.500
ø0.323 +0.005 -0.000 (THRU, TYP)
HOLE TO BE ALIGNED WITHIN ±0.001 OF HOLE ON OTHER SIDE OF CUFF, TO BE DRILLED AFTER BENDING
3
SECTION B-B
SCALE 1:2
MS21920-20 CLAMP (REF)
D3502-1 SUPPORT (REF)
GAP (REF)
D2856-400-710 ABRASION STRIP (REF) 8
UNDER REVIEW
RELEASED
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DESIGN
DRAWN BY
CHECKED
APPROVED
DATE
06.10.31
DART
DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D350-748-241
REV. D
SHEET 2 OF 3
TITLE
CROSSTUBE (AS 350/355 HI AFT)
SCALE
1:6
SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER
NO. 3190A



D350-748-241 MACHINING DETAIL



DETAIL C: CUFF
SCALE 1:1



DETAIL D:
CUFF TRANSITION
SCALE 9:1

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D350-748-241 REV. D SHEET 3 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE 1:4

RELEASE NOTE

AC AERO
INTERNATIONAL INC.

GST No. : R105468102

...RS ROAD, OAKVILLE, ONTARIO
...A L6L 2X5
(905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6I 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

OAK 87500-1

05/29/2007
MM / DD / YYYY

PAGE : 1

1DAR01

/O: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

SHIP TO : DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
05/29/2007	EPIC 4300450343	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3777		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141, 241	EA	10	10	100% HARDNESS TESTED 10pcs → 42/43 HRC

Procedure: 4353

Process Specifications:
HEAT TREATED TO 180-200 KSI PER AMS 2759-1C
100% HARDNESS CHECKED AS PER ASTM E-18
HRC 40-43
MATERIAL: 4130

SAND BLASTED

P/S# 59141
6 PIECES P/N D350-748-141,
S/N B31901A, B31902A, B31903A,B31904A, B31905A, B31906A
4 PIECES P/N D350-748-241,
S/N B31907A, B31908A, B31909A,B31910A

NOTE: NO SERIAL NUMBERS FOUND ON PARTS

V.A.I.O. TH. 27 Q.C.

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

V.A.I.O. TH. 27 Q.C.

Authorized Q.C. Inspector

Nadcap PRI PERFORMANCE REVIEW INSTITUTE Accredited HEAT TREATING

...TREATING SPECIAL PROCESSING · FURNACE EQUIPMENT

CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1

DATE: Aug-13-2007

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 68799
INVOICE #: 35484

CONTRACT OR PURCHASE ORDER # 4203

DESCRIPTION: SKID **QTY** 1

P/N # D350748241 **S/N #** B31907A

CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1.MPI IAW ASTM-E-1444. AND ACCEPTED BAKE HEAT CHARTS#8066 & 8136

CERTIFCATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector: Ray Last R. LAST

CAI 01

Dart Aerospace Ltd.

Date: Thursday, 23/08/2007 10:54:14 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: UPDATE PAPERWD350-748
Job Number	: 34248		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: Z_CUSTOM
This Issue	: 23/08/2007 **S.O. No.** : N/A	**Drawing Number**	: ECN 1012
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 30/08/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO STK
PER ECN 1012

D350-748-101 BATCHES: 3/901, 3/913, 3/902

D350-748-201 BATCHES: 3/907, 3/910 3/908

RETURN TO STK

7/8/24 SP

Seq. #:	Machine Or Operation:	Description :
2.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion

09.08.24